

Split

Dart Aerospace Ltd.

Date: Monday, 02/03/2009 9:05:13 AM
User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 46146 -2
Estimate Number : 10564
P.O. Number :
This Issue : 02/03/2009 S.O. No. :
Prsht Rev. : NC
First Issue : 11 Type : MACHINED PARTS
Previous Run : 44029
Written By :
Checked & Approved By : [Signature]
Comment : Est Rev: A 05.11.14 New issue EC

Drawing Name : STRUT WELDMENT ASS'Y
Part Number : D34433
Drawing Number : D3443 REV B
Project Number : N/A
Drawing Revision : B
Material :
Due Date : 16/03/2009 Qty: 20 Um: 10

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M304R1500 304 round bar 1.500



M106260



Comment: Qty.: 0.2500 f(s)/Unit Total: 5.0000 f(s)

09/03/03

26

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL
1-TURN AS PER FOLIO FA588 & DWG D3443
FOLIO REV: AA
DWG REV: B

09/03/03

26

2-DEBURR AS REQUIRED

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/03/03

26

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA588 Rev: B & Dwg D3443 Rev: B

9

2-Deburr per dwg D3443

MAF 09/03/14 MA 09/03/05

J.L

re:
ser:

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Drawing Name: STRUT WELDMENT ASSY

Job Number: 46146

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Seq. #: Machine Or Operation:

Description:

5.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(8)



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ma 09/03/14 N.A 09/03/05

6.0 MILLING CONV.

CONVENTIONAL MILLING MACHINE



(8)



(P70)

Comment: CONVENTIONAL MILLING MACHINE
Drill hole as per Dwg D3443.

N.A 09/03/14

7.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(8)



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N.A 09/03/14

8.0 QC8

SECOND CHECK



(8)

Comment: SECOND CHECK

ma 09/03/16

(8)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: W/A

N 9-3-16

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

ma 09/03/16

Job Completion


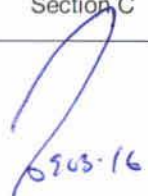








W 09.03.16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: 83443-3 PAR #: N/A Fault Category: Prod / Machined Parts NCR: Yes No DQA: A Date: 09/03/16
 Resolution: _____ Disposition: _____ QA: N/C Closed: A Date: 09/03/16

NCR: <u>46146-2</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/03/16	4.0	1 part turned/shifted in the machine during facing, causing a 0.035" chamfer x 0.260". R.C. process		Scrap: destroy qty 1	N.A. 09/03/16			
09/03/16	6.0	1 part the ±1.30 hole was started in the wrong orientation. R.C. operator error.		Deburr and drill as per drawing the correct hole orientation. Acceptable	N.A. 09/03/16			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD		Work Order: <i>H0146</i>
Description: Clevis		Part Number: D3443-3
Inspection Dwg: D3443	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

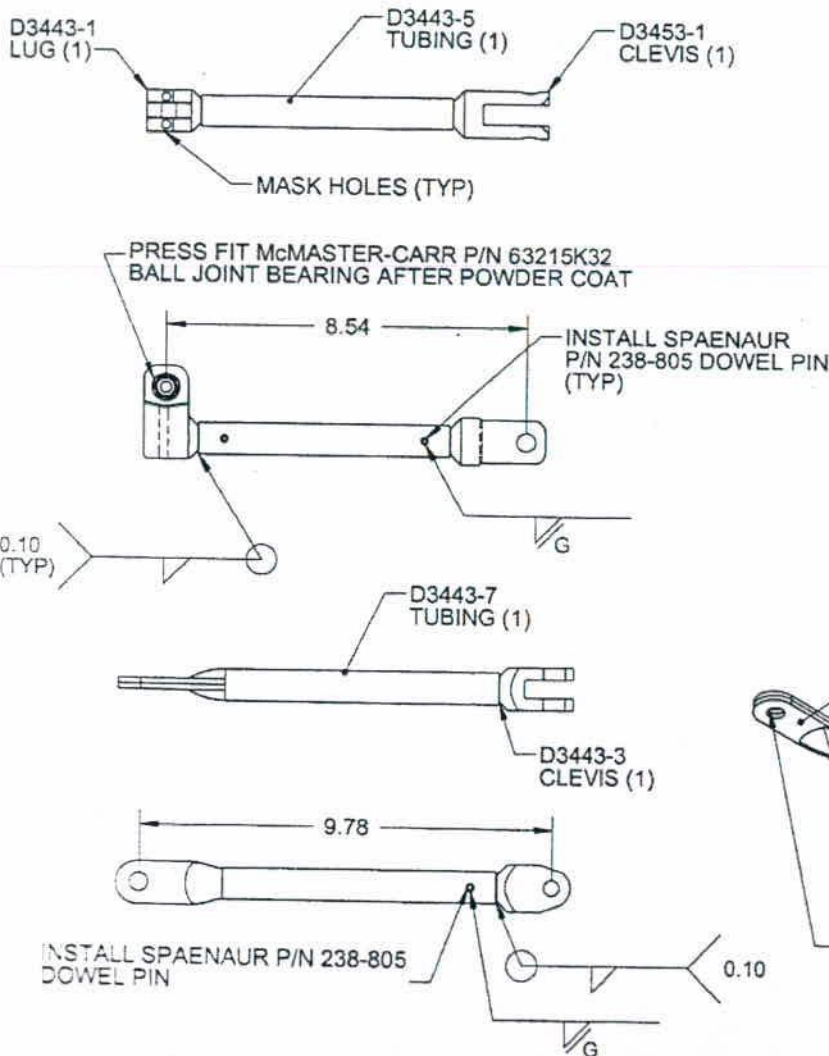
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.70	+/-0.030	2.719	✓			
0.95	+/-0.030	0.945	✓			
Ø0.500	+0.000/-0.005	0.497	✓			
20°	+/-0.5°	20°	✓			
R0.450	+/-0.010	R0.450	✓			
Ø0.375	+0.006/-0.001	Ø0.377	✓			
0.451	+/-0.010	0.404	✓			
0.625	+/-0.010					manual mill
1.53	+/-0.030	1.525	✓			
0.720	+/-0.010	0.719				
0.05 x 45°	+/-0.5°	0.045 x 45°	✓			
45°	+/-0.5°	45°	✓			
1.00	+/-0.030	1.001	✓			
1.125	+/-0.010	1.124	✓			
0.438	+0.005/-0.000	0.439	✓			
R0.050	+/-0.010	R0.050	✓			

Measured by: <i>g</i> / <i>B.A</i>	Audited by:	Prototype Approval:	N/A
Date: <i>09/03/08</i>	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.28	New Issue	KJ/JLM	<i>[Signature]</i>

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY SCALE 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & Ø 0.125 WAS #30	

RELEASED05.12.09 *[Signature]***D3443-041****D3443-043**SHOP COPY
RETURN TO
ENGINEERING**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

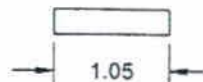
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DART

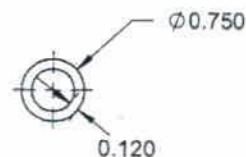
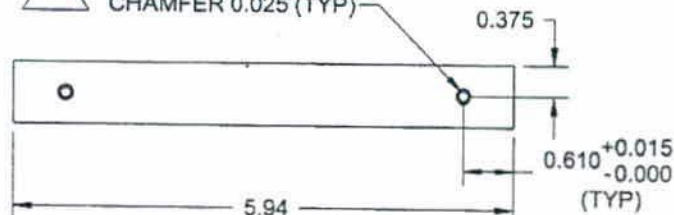
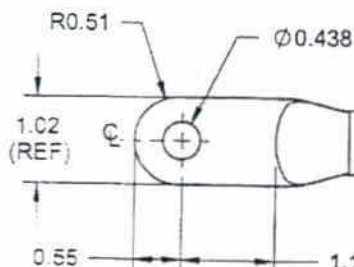
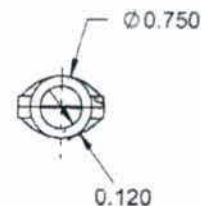
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
CHECKED #	APPROVED #	DRAWING NO. D3443	SHEET 3 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 12	SCALE	

 $\phi 0.210^{+0.005}_{-0.010}$ **D3443-9 PIN****D3443-9 NOTES:**

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.12.09

DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)**D3443-5 TUBING** $0.260^{+0.000}_{-0.030}$ DRILL $\phi 0.125$ THRU
CHAMFER 0.025**D3443-7 TUBING****D3443-5/-7 NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.750X1.125)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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